

# Work Order ID 77720

December-19-11 8:24:58 AM

*ASAP*  
**\*77720\***

Page 1

Item ID: D3693-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rod End Bearing  
 Start Date: 19/12/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 02/01/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3693	B

100 PURCHASING 0.00  
**\*100\***  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 15486 Purchase Part Number: 205-060-101-001 Supplier:  
 Bell Certificate of conformity is required

*11-12-19*  
*(4)*

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging Ensure certificate of conformity is attached

*11/21/20*  
*(4)*

120 QC6- Inspect dimensions to drawing 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control

*5/11/20*

*(46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77720

**\*77720\***

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December-19-11 8:24:58 AM

Item ID: D3693-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Rod End Bearing

Start Date: 19/12/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

**\*130\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-FILL CAVITY WITH HYSOL AS PER DWG D3693HYSOL ADHESIVE  
EA934NA BATCH: mw114 AS PER MANUFACTURE  
INSTRUCTION

*M* 12-01-13 (6)

150

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

1-DRILL AS PER DWG using DT9515  
2- DEBURR

*S/FF* 12-01-26 (6)

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*Sizel/24* (76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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December-19-11 8:24:58 AM

**\*77720\***

Page 3

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/1/268 (6)

12/1/30 J

R 12-01-27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

December-19-11 8:25:02 AM

Page 1

Work Order ID: 77720

\*77720\*

Parent Item: D3693-3

\*D3693-3\*

Parent Item Name: Rod End Bearing

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-01-17 JLM Verified By:EC  
IPP Rev:B As per Rev B 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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205-060-101-001

Purchased

No

Each

0.0000

6

\*205-060-101-001\*

\*\*

Rod Bearing End

*Revised 11/14/20*

24688

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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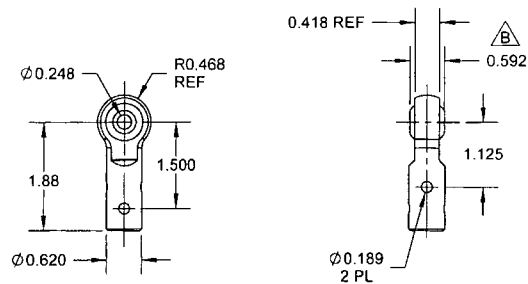
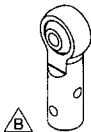
**NOTE:** Date & initial all entries



# **SPECIFICATION CONTROL DRAWING**

SEE NOTE  
REFER TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

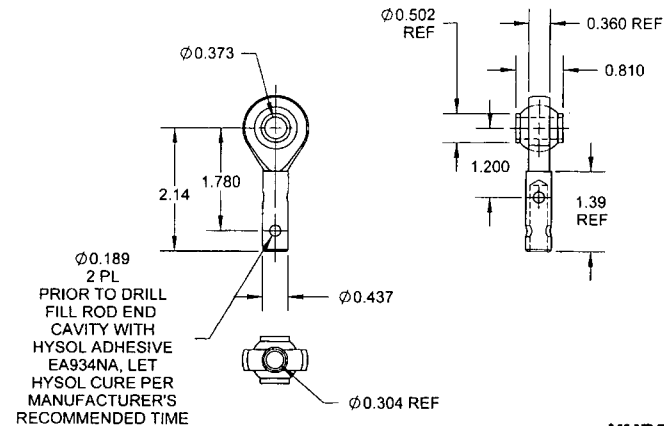
37720 M.L.S  
11/12/19



**D3693-1  
ROD END BEARING**

DART P/N	DESCRIPTION	BELL P/N	WEIGHT (lb)	FINISH	IDENTIFY
D3693-1	ROD END BEARING	047-140-252-005	0.19	NONE	NONE
D3693-3	ROD END BEARING	205-060-101-001	0.14	NONE	NONE

SEE NOTE  
REFER TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



$\phi 0.189$   
2 PL  
PRIOR TO DRILL  
FILL ROD END  
CAVITY WITH  
HYSOL ADHESIVE  
EA934NA, LET  
HYSOL CURE PER  
MANUFACTURER'S  
RECOMMENDED TIME

**D3693-3  
ROD END BEARING**

**UNDER REVIEW**

09.05.19  
PAR 09-019

**RELEASED**  
09/01/2019

B	REMOVED SHADED VIEW (ZN D8-1, D1-1); 0.592 WAS 0.591 (ZN CS-1); REFORMATTED SHEET; TRANSFORMED GENERAL NOTES TO TABLE FORMAT	RF	08.12.15
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3693** REV. B  
SHEET 1 OF 1  
TITLE **ROD END BEARING** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO15686**

Purchase Order Date 12/19/2011

PO Print Date 12/19/2011

Page Number 1 of 1

**Order From :**

VC-EAG002

EAGLE COPTERS MAINTENANCE LTD.  
823 MCTAVISH ROAD  
CALGARY, AB T2E 7G9  
CA

**Contact Name**

**Vendor Phone**

403 250 7370

**Vendor Fax**

403 250 7110

**Vendor Account Nbr**

**Buyer**

Brigitte Golden

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 15

**Currency**

CAD

**FOB**

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	205-060-101-001	Rod Bearing End	12/20/2011 Yes	6.00 Each	FedEx Overnight	\$246.0000	\$1,476.00

**Special Inst:** As per Dwg: D3693  
Rev: B  
B77720  
Bell p/n: 202-060-101-001

**PO Total:**

**\$1,476.00**

Change Nbr: 1

Change Date: 12/19/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# Eagle Copters Maintenance Ltd

823 McTavish Rd, NE  
Calgary, Alberta T2E 7G9  
Canada

## Packing Slip

Shipped Date: 12/19/2011

Telephone: (403) 250-7370

Fax: (403) 250-7110

Shipment number: SH#11-003432

Ship To: Dart Aerospace Ltd.

1270 Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship Via: FED EX

Carrier Terms:

Waybill: 7978 6363 6050

Customer PO number:

Phone: 613-632-5200

Item	Part Number	Part Description	Current Location	Qty	UOM	Serial Number	Lot Number
1	205-060-101-001	ROD END	Shipping Area	6	Each		LT-11-016173
Type of sale:		Outright	Sum 11/2/20				

Sales Order Number: SO11-01813.001

Eagle P.O. Number: PO-11-004495.1

Please ship Fedex P1 acct# 1092 2342 5

All Parts being sent on this packing slip have the original certification on file at Eagle Copters Ltd.

\* End of Report \*

>> denotes that the Packing Slip line item has already been printed.

Eagle\_PackingSlipV1.rptl

Form 9727 v109

Printed: 12/19/2011 3:39:54PM

Ref: 139

Eagle Copters Maintenance Ltd  
923 McTavish Road, NE Calgary, Alberta T2E 7G9

TCCA AMO Approval No. 6-81

LOT #: LT-11-016173



Sold To: SO11-01813.001

Sold Date: 12/19/2011 8:44:53PM

PART #: 205-060-101-001

Description: ROD END

Serial No.

Condition: New

Qty Sold:

6.00

Cure Date:

Manufacturer: Bell Helicopter (Manufacturer)

Cycles

Hours

Total Time

0.00

TSO:

Time Remaining:

Details of work performed/reason for removal

Receiving Inspection

Additional work to be performed upon installation

December 19, 2011

Inspector

Lic. No./Stamp

